

Work Order ID 136327

September 02, 2015 11:26:57 AM

136327

Page 1

Item ID: D4785-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Base Assembly, LH/RH
Start Date: 9/2/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/9/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: SLT Date: 20150902 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4785	B								
100	Weld per dwg A/R S.S. rod Batch: <u>4131417</u>	0.00						DAS 43 9-89	SEP 16 2015
100	Large Fab								
Large Fab	Memo	0.00							
	1- Use DT9610A to assemble contour ribs and the (2) D3916-5 ribs , weld as per dwg D4785 ***inspect before welding mesh*** ***ENSURE BOTTOM OF BASE RIB ARE STRAIGHT***								
	2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D4785 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends ***USE DT10158 WITH SHIM WHEN WELDING BOTTOM OF RIB D4785-115*** ***ENSURE BOTTOM OF BASE RIB ARE STRAIGHT***								
	3- weld hinge (3) and Mounting brackets as per dwg D4785 ***take lid to locate hinge and bracket***								
	4- Weld D4672-1 blanking plates as per dwg ***ENSURE BOTTOM OF BASE RIB ARE STRAIGHT***								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : ☐																					

Work Order ID 136327

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Page 2

Item ID: D4785-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Long Basket Base Assembly, LH/RH

Stop ***NS2***

Start Date: 9/2/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/9/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo ***ENSURE BOTTOM OF BASE RIB ARE STRAIGHT*** Use DT10160 jig to ensure D4785-115 holes are align after welding	0.00 0.00				1	SEP 16 2015		DAS 24 9-89
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo ***ENSURE BOTTOM OF BASE RIB ARE STRAIGHT*** Use DT10160 jig to ensure D4785-115 holes are align after welding	0.00 0.00				1	SEP 16 2015		DAS 24 9-89
125 *125* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00				1	15-9-17.		DAS 34 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	1- Plug holes and mask only interior of hinge (3) prior to powder coat <i>M 131545</i> 1ST COAT: START TIME: <i>9:10</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>9:40</i> ***** 2nd coat if necessary ***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____							<i>1</i> <i>15-4-17</i> <i>2338</i>	
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									<i>1</i> <i>12/08/15</i> <i>DAS 15 9-89</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Cust Item ID:
Customer:

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 136327

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Page 5

Item ID: D4785-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Long Basket Base Assembly, LH/RH

Start Date: 9/2/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/9/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

SEP 21 2015

MLJ SEP 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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Page 1

Work Order ID: 136327

136327

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 9/2/2015

Required Date: 9/9/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.03.14 NEW ISSUE DD VERF:JLM IPP
REV:B 13.06.17 as per dwg rev.pb1 DD VERF:JLM IPP REV:C
13.07.04 revise bom per dwg rev.B DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4785-1		Manufactured	No			100	Each	6.0000	2	2		DAS 43 9-89	
✓ *D4785-1*									**			SEP 11 2015	
Rib													
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				6					
					133295			6					
D4785-5		Manufactured	No			100	Each	12.0000	3	3		DAS 43 9-89	
✓ *D4785-5*									**			SEP 11 2015	
Rib													
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				12					
					121284			6					
					133297			6					
D4785-115		Manufactured	No			100	Each	0.0000	4	4		DAS 43 9-89	
✓ *D4785-115*									**			SEP 11 2015	
Rib Assembly													
D4785-117		Manufactured	No			100	Each	0.0000	2	2		DAS 43 9-89	
✓ *D4785-117*									**			SEP 11 2015	
Rib Assembly													
D4785-3		Manufactured	No			100	Each	6.0000	2	2		DAS 43 9-89	
✓ *D4785-3*									**			SEP 11 2015	
Rib													
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				6					
					133300			6					

B133295 → 2

B121284 → 3

** B136330 → 4

** B136331 → 2

B133300 → 2

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D4785-041

Required Date: 9/9/2015

Required Qty: 1.00

DAS

****** B 136330 → 3 ⁴³ SEP 11 2015

DAS

43
2.89 SEP 11 2015

B135906 → 98

Loc Code

Journal of Management Inquiry 23(1) 3-17

1 1

DAS

43
9-89 SEP 11 2015

B135908 → 1

Loc Code

2 2

DAS

43
9-89 SEP 11 2015

B135336 → 2

Loc Code

1 1

DAS

43
9-89 SEP 11 2015

B135329 → 1

Loc Code

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Picklist Print

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Work Order ID: 136327

136327

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 9/2/2015

Required Date: 9/9/2015

Start Qty: 1.00

Required Qty: 1.00

D3913-3 Manufactured No

100 Each

5.0000

1 1

DAS

43

SEP 11 2015

✓ ***D3913-3***

Rib

**

B135995 → 1

Location

Loc Qty

Loc Code

WA004

5

135995

5

D3913-9 Manufactured No

100 Each

5.0000

1 1

DAS

43

9-89

SEP 11 2015

✓ ***D3913-9***

Hinge Rib

**

B135328 → 1

Location

Loc Qty

Loc Code

WA004

5

132432

1

135328

4

D4793-1 Manufactured No

100 Each

6.0000

3 3

DAS

43

9-89

SEP 11 2015

✓ ***D4793-1***

Handle Plate

**

B119401 → 3

Location

Loc Qty

Loc Code

WA004

6

119401

6

D4793-3 Manufactured No

100 Each

1.0000

1 1

DAS

43

9-89

SEP 11 2015

✓ ***D4793-3***

Handle Plate, Wide

**

B121286 → 1

Location

Loc Qty

Loc Code

WA004

1

121286

1

Picklist Print

September 02, 2015 11:27:05 AM

Page 4

Work Order ID: 136327

136327

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 9/2/2015

Required Date: 9/9/2015

Start Qty: 1.00

Required Qty: 1.00

D4672-1 Manufactured No

150 Each 21.0000 2 2

DAS

43

9-89

SEP 11 2015

✓ *D4672-1*

Blanking Plate

**

B135409 → 2

Location

Loc Qty

Loc Code

WA004

21

125138

1

128829

12

135409

8

D4021-5 Manufactured No

100 Each 28.0000 2 2

D4021-5

Blanking Plate

**

all 15/09/15

Location

Loc Qty

Loc Code

ST081

28

103829

5

131357

2

135339

21

X2

M304EX0.75-16F Purchased No

100 sf 842.1534 33 33

✓ *M304FX0 75-16F*

Expanded Metal Flat SS

**

4132587 → 33 06

Location

Loc Qty

Loc Code

WA004

594.8922

M132271

15

M132587

32

M132745

326.8922

M132864

61

M132967

160

WA006

247.2612

M131107

82.8612

M131629

164.4

Picklist Print

September 02, 2015 11:27:05 AM

Page 5

Work Order ID: 136327

136327

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 9/2/2015

Required Date: 9/9/2015

Start Qty: 1.00

Required Qty: 1.00

D4020-11

Manufactured No

100 Each

14.0000

2 2

✓ ***D4020-11***

End Mesh, Basket

B135283 → 2

Location

Loc Qty

Loc Code

WA006

14

135283

14

D4016-1

Manufactured No

100 Each

15.0000

3 3

✓ ***D4016-1***

Hinge Half, Base

DAS
43
9-89

SEP 11 2015

B132394 → 2
B135902 → 1

Location

Loc Qty

Loc Code

WA004

15

132397

5

135902

10

D2931

Manufactured No

150 Each

1,715.000

2 2

D2931

Bumper

all 10/09/17

Location

Loc Qty

Loc Code

ST013

92

86435

92

ST025A

1623

86435

1623

D2581

Manufactured No

100 Each

63.0000

2 2

✓ ***D2581***

Mounting Bracket

DAS
43
9-89

SEP 11 2015

B132771 → 2

Location

Loc Qty

Loc Code

WA004

63

132771

63

Picklist Print

September 02, 2015 11:27:05 AM

Page 6

Work Order ID: 136327

136327

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 9/2/2015

Required Date: 9/9/2015

Start Qty: 1.00

Required Qty: 1.00

AN3-10A

Purchased

No

150

Each

176.0000

6

6

AN3-10A

Bolt

ll 12/09/17

Location

Loc Qty

Loc Code

GA

8

m132317

8

ST338a

100

m132763

100

ST349

68

m132317

18

m133064

50

26

MS20600-AD4W3

Purchased

No

150

Each

572.0000

2

2

MS20600-AD4W3

Cherry Rivets

ll 12/09/17

Location

Loc Qty

Loc Code

GA

216

m129795

216

ST309

272

m132680

272

WA003

84

m130018

84

22

Picklist Print

September 02, 2015 11:27:05 AM

Page 7

Work Order ID: 136327

136327

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 9/2/2015

Required Date: 9/9/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

1,033.000

6

6

MS21042L3

Nut

all 10/1/17

Location

Loc Qty

Loc Code

FP001

384

M130922

384

11133131

✓6

GA

227

M131317

227

ST305

422

116549

12

126333

49

M128754

2

M132123

17

M132382

2

M132883

17

M132930

323

NAS1149DN832J

Purchased

No

150

Each

1,658.000

2

2

NAS1149DN832J

Washer

all 10/1/17

Location

Loc Qty

Loc Code

CA

84

M129499

84

MF4

185

M129541

185

ST260a

1389

M131697

1389

✓7

Picklist Print

September 02, 2015 11:27:05 AM

Page 8

Work Order ID: 136327

136327

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 9/2/2015

Required Date: 9/9/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

1,913.000

12

12

NAS1149F0332P

all c il o e l c z

Washer

Location

Loc Qty

Loc Code

GA

210

122063

210

ST260a

1610

m128401

6

m131026

80

m131697

524

m133077

1000

st268

93

123900

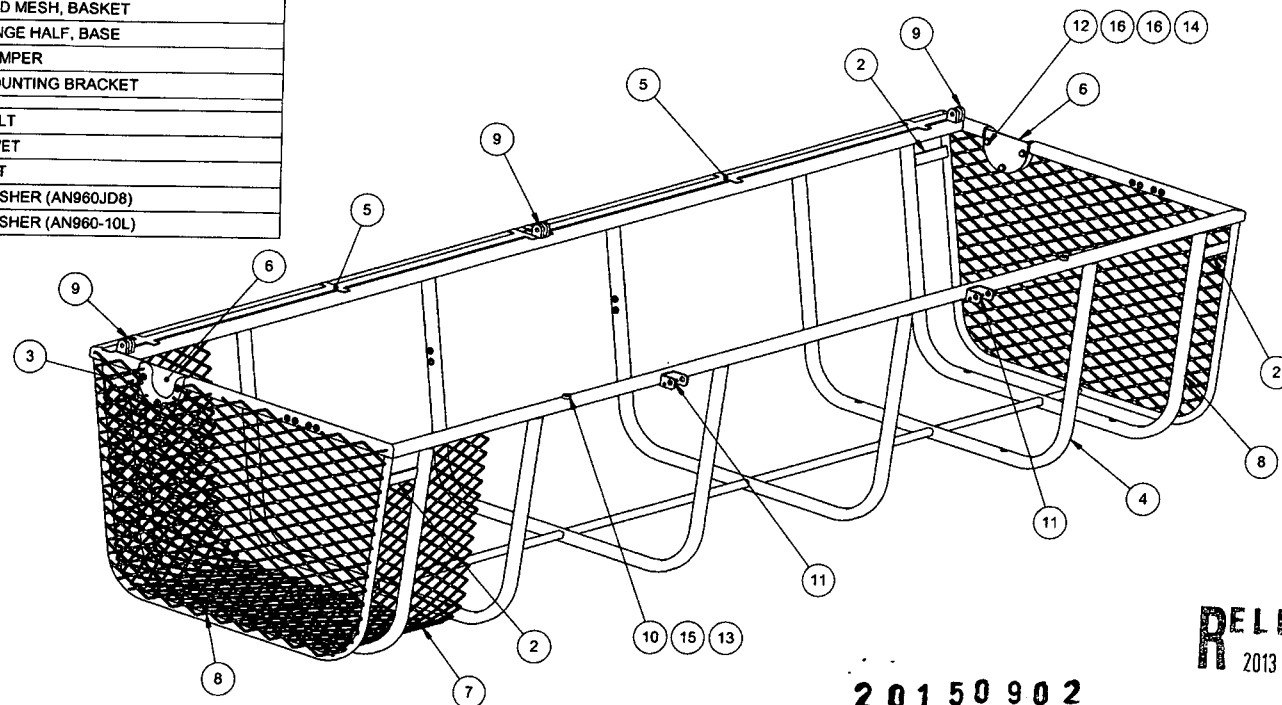
7

m130388

86

✓12

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4785-041	LONG BASKET BASE ASSY, LH/RH
2	3	D4793-1	HANDLE PLATE
3	1	D4793-3	WIDE HANDLE PLATE
4	1	D4785-101	TUBULAR ASSEMBLY, LH/RH
5	2	D4672-1	BLANKING PLATE
6	2	D4021-5	BLANKING PLATE
7	1	D4020-1	MESH BASKET LONG, BASE
8	2	D4020-11	END MESH, BASKET
9	3	D4016-1	HINGE HALF, BASE
10	2	D2931	BUMPER
11	2	D2581	MOUNTING BRACKET
12	6	AN3-10A	BOLT
13	2	MS20600AD4W3	RIVET
14	6	MS21042L3	NUT
15	2	NAS1149DN832J	WASHER (AN960JD8)
16	12	NAS1149F0332P	WASHER (AN960-10L)



D4785-041 LONG BASKET BASE ASSY, LH/RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 50.42 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

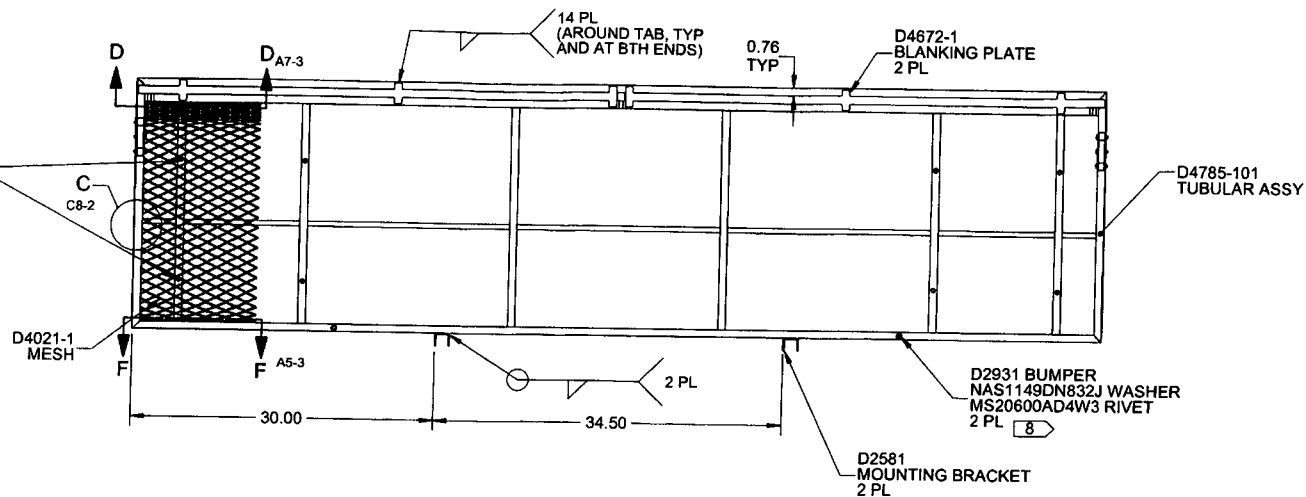
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2013-06-20

20150902

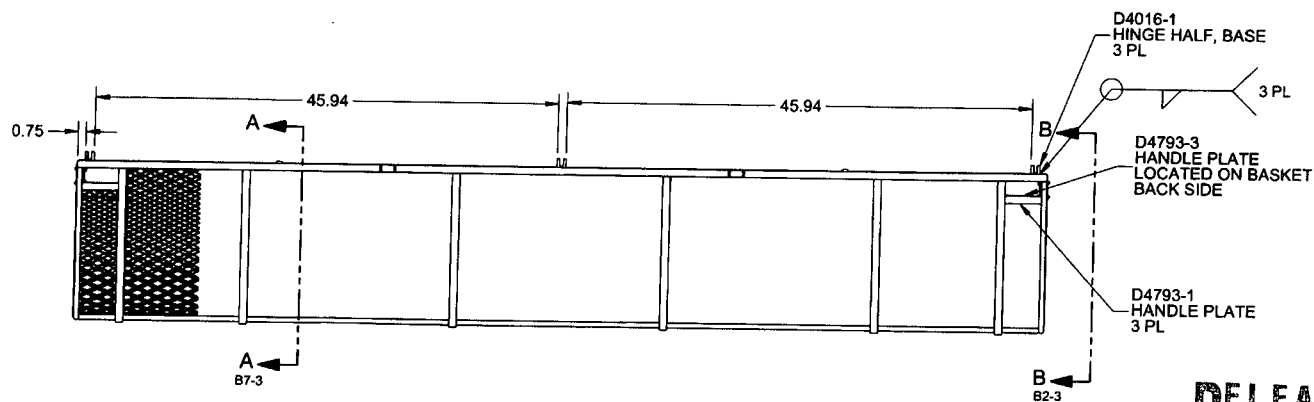
136327 5H

B	REPLACE D3916-5 WITH D4785-117 (ZN B5-4, B4-4, B5-7); REVISE D4785-5 DIMENSION (ZN B5-5)	RF	13.06.11
A	NEW ISSUE	RF	13.05.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. B
CHECKED	SC	D4785	SHEET 1 OF 7
MFG. APPR.	DS	TITLE	SCALE
APPROVED	SC	LONG BASKET BASE ASSY	NTS
DE APPR.	SC	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	13.06.11		

TRIM MESH LOCALLY
Ø0.50 - Ø0.60
TO CLEAR BUSHINGS
TYP



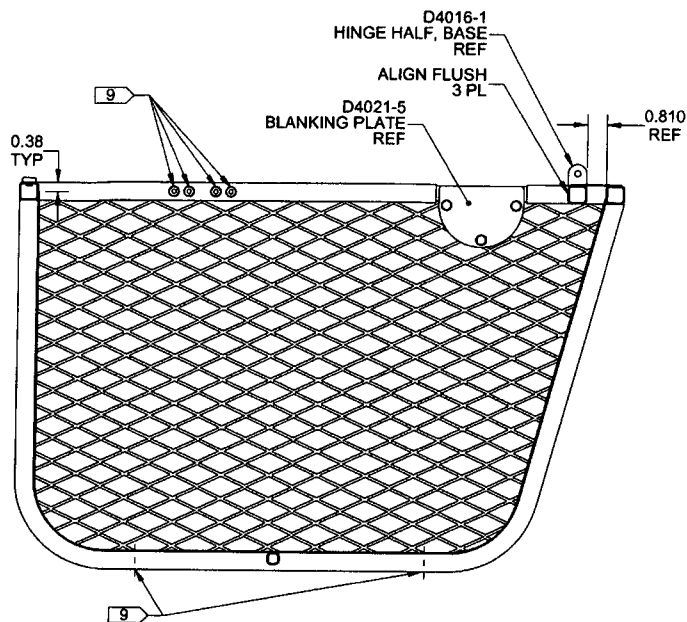
DETAIL C D7-2



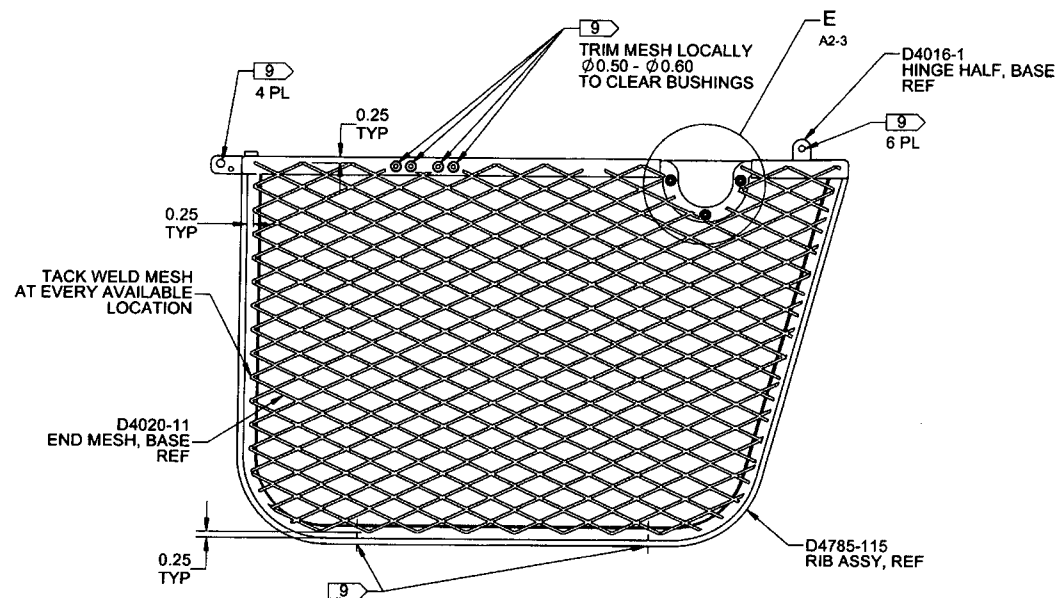
D4785-041 LONG BASKET BASE ASSY, LH/RH
(MESH SHOWN LOCALLY FOR CLARITY)

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2013-06-20

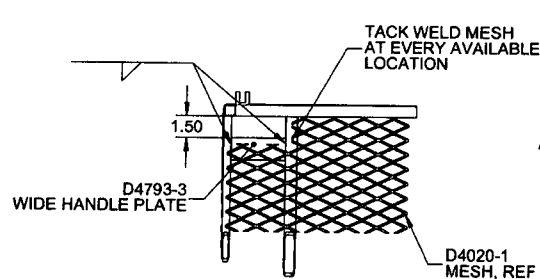
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DRAWN	RF		
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	N	D4785	SHEET 2 OF 7
APPROVED	#	TITLE	SCALE
DE APPR.	#	LONG BASKET BASE ASSY	NTS
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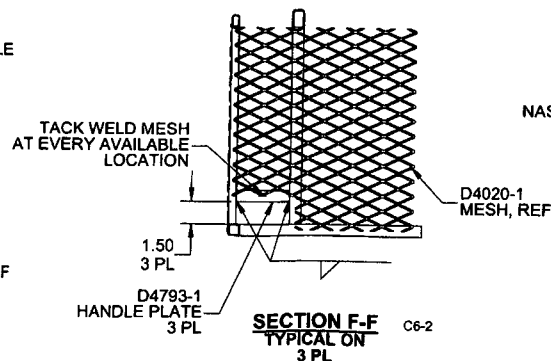
SECTION A-A B7-2



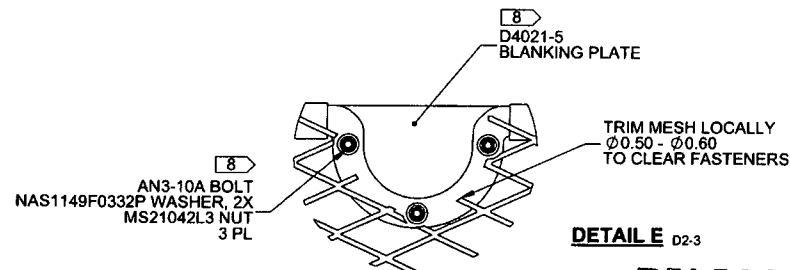
SECTION VIEW B-B A2-2



SECTION D-D D6-2



SECTION F-F C6-2
TYPICAL ON 3 PL

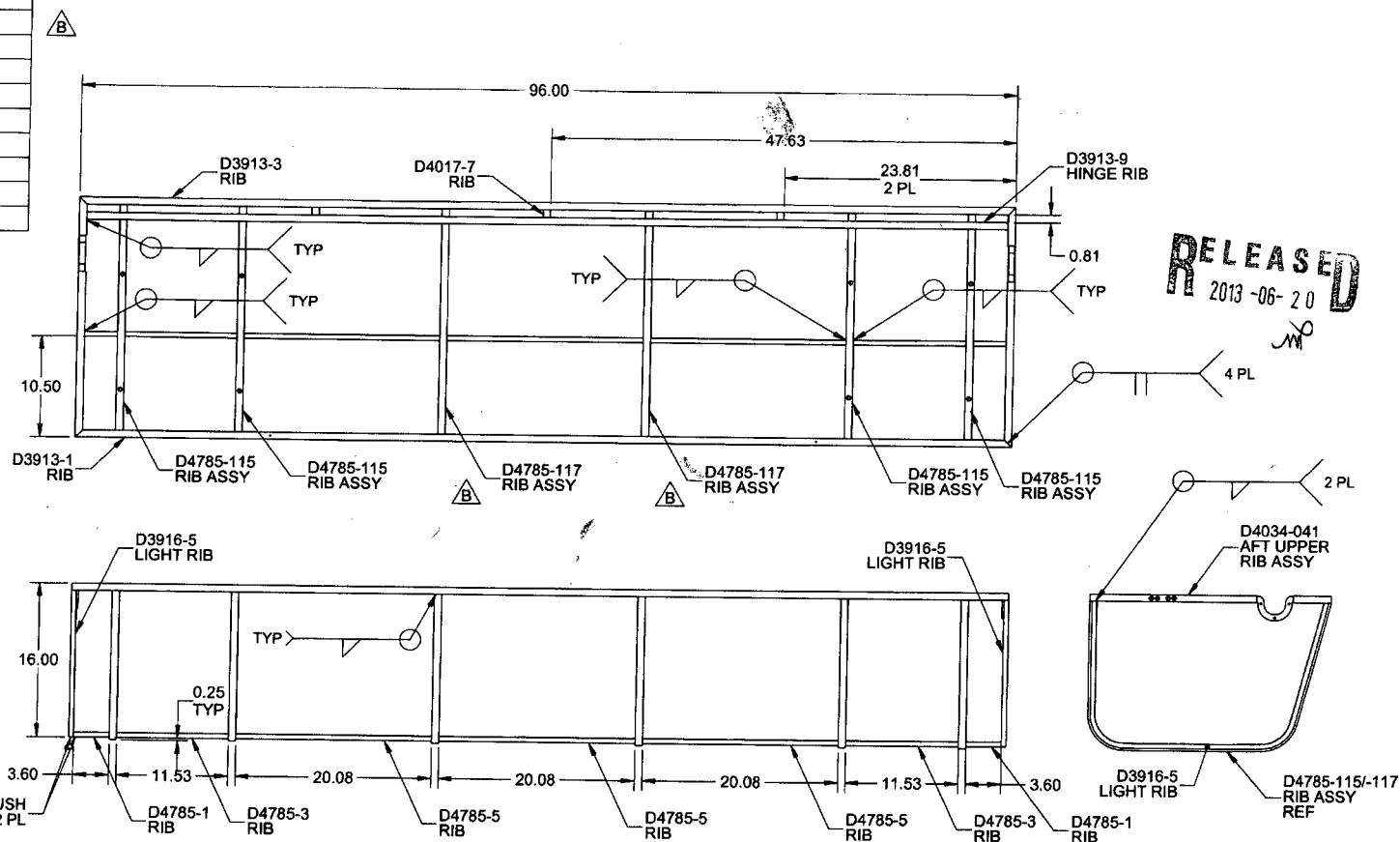


DETAIL E D2-3

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2013-06-20

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	N	D4785	SHEET 3 OF 7
APPROVED	#	TITLE	SCALE
DE APPR.	#	LONG BASKET BASE ASSY	NTS
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ITEM NO.	QTY. -101	PART NUMBER	DESCRIPTION
1	X	D4785-101	TUBULAR ASSEMBLY
2	2	D4785-1	RIB
3	3	D4785-5	RIB
4	4	D4785-115	RIB ASSEMBLY
5	2	D4785-117	RIB ASSEMBLY
6	2	D4785-3	RIB
7	3	D4017-7	RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY
10	2	D3916-5	RIB, LIGHT
11	1	D3913-1	RIB
12	1	D3913-3	RIB
13	1	D3913-9	HINGE RIB

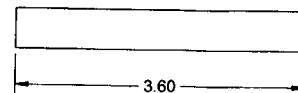


NOTES:

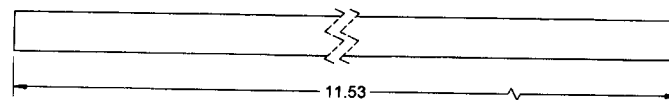
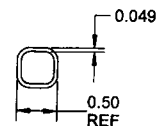
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.65 lbs
- 8) WELD PER DART QSI 004

D4785-101 TUBULAR ASSEMBLY, LH/RH

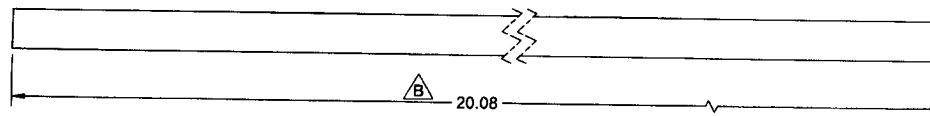
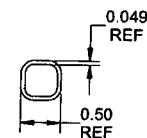
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D4785	SHEET 4 OF 7
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LONG BASKET BASE ASSY	NTS
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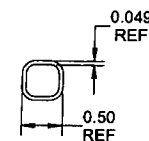
D4785-1 RIB



D4785-3 RIB



D4785-5 RIB



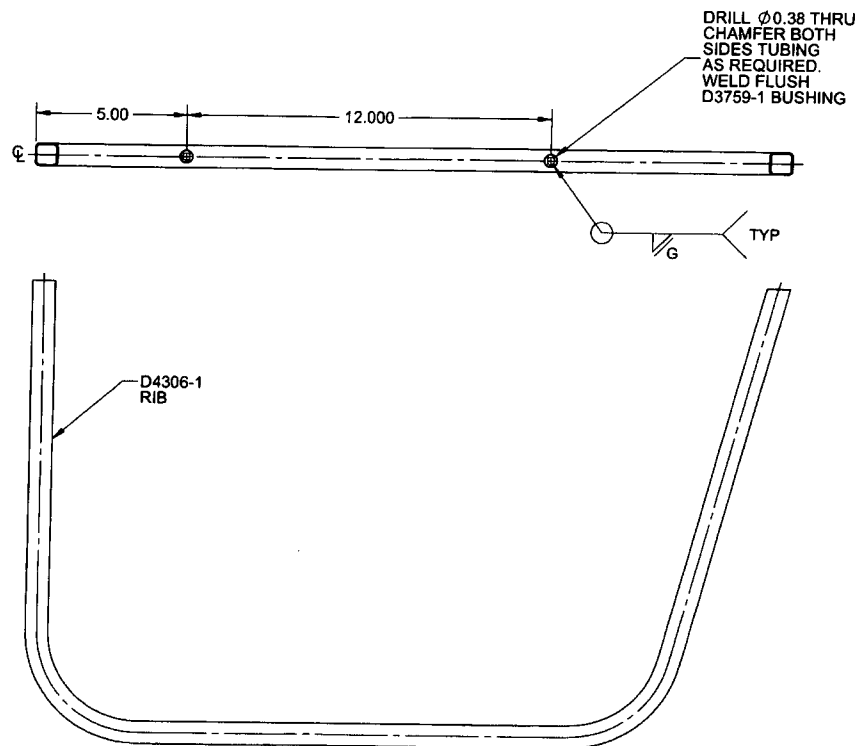
NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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2013-06-20
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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>PC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>N</i>	D4785	SHEET 5 OF 7
APPROVED	<i>#</i>	TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY	NTS
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ITEM NO.	QTY. -115	PART NUMBER	DESCRIPTION
1	X	D4785-115	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D3759-1	BUSHING



D4785-115 RIB ASSEMBLY
MAKE FROM D4306-1 RIB

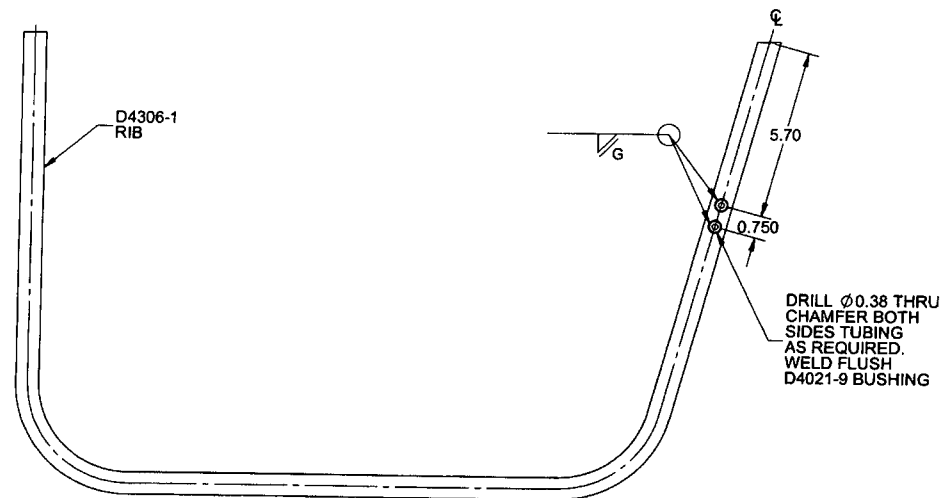
RELEASED
2013-06-20
JND

NOTES:

- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.80 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. B
MFG. APPR.	JND	D4785	SHEET 6 OF 7
APPROVED	JND	TITLE	SCALE
DE APPR.	JND	LONG BASKET BASE ASSY	NTS
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ITEM NO.	QTY. -117	PART NUMBER	DESCRIPTION
1	X	D4785-117	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D4021-9	BUSHING



D4785-117 RIB ASSEMBLY 
MAKE FROM D4306-1 RIB

NOTES:

- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.81 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>SC</i>	DRAWING NO. D4785	REV. B
MFG. APPR.	<i>SC</i>	TITLE LONG BASKET BASE ASSY	SHEET 7 OF 7 SCALE NTS
APPROVED	<i>SC</i>	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	<i>SC</i>		
DATE	13.06.11		

RELEASED
2013-06-20